## \*90770\*

	er ID 90770 200:33:50 AM		*907	770*					Page 1
Item ID: Revision ID: Item Name:	D350-591-312 Heli-Access-Step, Long RH		Accept	*N900	04010	<b>n</b> *	Setup Start Stop	*NS	31* 32*
Start Date: Required Date: Reference:	9/26/12 <b>Start Qty:</b> 10.00 <b>Req'd Qty:</b> 10.00	*10* *10*		Cust Item I Customer:	D:				
Approvals:	Process Plan:QC:				ate:	1	Run Start Stop	*NF	२1* २ <b>2</b> *
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty		-	Insp. Stamp
Draw Nbr	Revision Nbr								
D3272	Rev B								
*1 \\n^* \\ DC \\ Document Control	DOCUMENT CONTRO  Memo  Photocopy	OL bluefile and type labels as pe		7/10/27 CHG001		7	<u> 461</u> 1	nct le	0-10-18
110			0.00						N
*110* Large Fab	Large Fab <b>Memo</b>		0.00			10	— J		12.10.10
Large Fab	2-Weld Sup D3272	for welding FWD ONLY port using Jig DT8719, weld ninum Rod 11235	Fwd End Plate as per (	QSI 004 & Dwg					12.10.10 Ae 12.10

NCR: \	Yes / No				WORK ORDER NON-O	COI	NFORI	MANCE / UPI	DATE			•
	,									QA Closed:	Date:	
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	•
					Rework	]		Skid-tube	Crosstube	]	Water Jet	Engineering
Part N	No.				Scrap	1	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	1	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	No				Work Order Update	]		Large Fab	Composite	]	Supplier	
Root				Descri	I ption of work order update		Initial	Act	ion	Sign &		
Cause	Date	Step	Qty	C	or Non-conformance	Cr	nief Eng	Descr	ription	Date	Verification	QC Inspector
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	Bending			. —	Bend	_	Grain		ļ	Ovalized	ļ	Pressure/Forced
ļ	Centre No	ot Concer	ntric to (	D/S	BOM/Route	<u> </u>	Hardwa		-	Over/Under	<del>-</del>	Temperature/Cure
	Cracks			ļ	Broken/Damaged	<u> </u>	1 '	ion Incomplete		Part Incorre	<del> </del>	Weld
	Crushed/Crimped.				Burrs	$\vdash$	4	ions Incomplete/U	Jnclear	Part Lost/Mi	issing	Wrong Stock Pulled
}	Cuffs			ļ	Contamination	<u> </u>	Mainte		<u></u>	Part Moved		
	<b>├</b> ── <b>│</b>				Countersink	-	Mislabe		<u> </u>	Positioned V		J.,
}	Inspection Strip in Tube Cut Too Short				4	_	Misread	1	L	Power Loss/	Surge	Other
}	Ripples in Bend Drill Holes					-	Offset	- 1·1 ··				
}	Torque Waves in Extrusion				Drawing	-	4	Calibration				
	Turning S	equence		- 1	Finish	1	Out of S	Sequence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Work Order ID 90770 \*90770\* Page 2 September-26-12 10:33:50 AM Item 1D: D350-591-312 Accept \*N900040100\* Setup Start **Revision ID:** Heli-Access-Step, Long RH Item Name: \*10\* **Start Date:** 9/26/12 **Start Qty: 10.00 Cust Item ID:** Required Date: 10/19/12 Req'd Qty: 10.00 **Customer:** Reference: Run Start Process Plan: Approvals: Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID Description** Qty Number Stamp, **Run Hours** Code Qty 120 QC9- Inspect visual per QSI004- Fusion Welds 0.00 \*120\* QC 0.00 Memo Quality Control 0.00 Smb 0.00 12, 10 11 QC5- Inspect part completeness to step on W/O 130 \*130\* QC Memo Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

\*140\*
HandFinish

Hand Finishing

11011

Memo

0.00

12/10/12

NCR:	Yes / No				WORK ORDER NON-C	100	NFORM	MANCE / UPI	DATE			•
										QA Closed:	Date	:
Work Orde	er:			-	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	•
Part N	No				Rework Scrap Use-as-is Work Order Update		ſ	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update		nitial	Act	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
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		· · · · · · · · · · · · · · · · · · ·				AUL	T CATE	GORY			<u> </u>	<del></del>
Landir F	ng Gear			<del></del>	General		1		<u></u>	1		7. /-
1	Bending				Bend	L	Grain			Ovalized		Pressure/Forced
-		Not Conce	ntric to (	D/S	BOM/Route	<u> </u>	Hardwa		-	Over/Under	<b>⊢</b>	Temperature/Cure
}	Cracks				Broken/Damaged	-	•	on Incomplete		Part Incorred	<b>├</b>	Weld
}	Crushed/Crimped			ļ	Burrs	<u> </u>	ł	ions Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled
}	Cuffs				Contamination	<u> </u>	Mainte			Part Moved	Managar	
}	Heat Treat Inspection Strip in Tube				Countersink	-	Mislabe			Positioned V		Other
}			Tube	<u> </u>	Cut Too Short	-	Misread	1	<u>L</u>	Power Loss/	ourge	Totner
}	Ripples in Bend Torque Waves in Extrusion				Drill Holes	$\vdash$	Offset	Calibratia :-				
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Outside Dimensions

Date:

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Wave/Twist in Tube

\*90770\*

Page 3

Item ID: D350-591-312 Accept \*N900040100\* Setup Start Revision ID: Stop Item Name: Heli-Access-Step, Long RH **Start Date:** 9/26/12 **Start Qty: 10.00 Cust Item ID:** Required Date: 10/19/12 Req'd Qty: 10.00 **Customer:** Reference: Run Start **Approvals:** Process Plan: Date:\_\_\_\_ **Tooling:** Date: Stop QC: \_\_\_\_\_ Date: \_\_\_\_ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Number Stamp **Qty** 150 QC3- Inspect Part Finish 0.00 Smb \*150\* 19-10-19 OC 0.00 Memo Quality Control 180 0.00 Large Fab \*120\* Large Fab 0.00 Memo Large Fab 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/RAluminum Rod 12,2,35% 6-Grind End Plate flush

7-Install last rivet as per Dwg.

NCR:	Yes	/ No				WORK ORDER NON-C	10:	NFORI	MANCE / UPI	DATE			•
		•									QA Closed:	Date	:
Work Ord	or.					DISPOSITION			•	AGAINST DE	PARTMENT	/PROCESS	•
Part	•					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
Tait						Use-as-is			noforming	Finishing	ł.	re/Packaging	Other
NCR	No.					Work Order Update			Large Fab	Composite	,	Supplier	
Root					Descri	ption of work order update		nitial	Act	ion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
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Landi	ne G	ear				General	<u> </u>	CAIL					1
		Bending				Bend		Grain			Ovalized	Γ	Pressure/Forced
	-	Centre No	ot Concer	ntric to (	o/s	BOM/Route	$\vdash$	Hardwa	ire	<u> </u>	Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		ł	ion Incomplete		Part Incorre	<b>⊢</b>	Weld
	Cracks Crushed/Crimped.					Burrs	П	1	ions Incomplete/L	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs					Contamination		Mainte	nance		Part Moved		
		Heat Trea	t			Countersink		Mislabe	eled		Positioned V	Vrong	
		Inspection	n Strip in	Tube		Cut Too Short		Misread	t		Power Loss/	Surge	Other
	Ripples in Bend Drill Holes							Offset					,
		Torque W	aves in E	xtrusior	ı [	Drawing		Out of (	Calibration				
		Turning Se	equence			Finish		Out of S	Sequence				

Outside Dimensions

DQA:

Date: \_\_

Wave/Twist in Tube

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<b>Work Ord</b> September-26-1.				*907	770*						Page 4
Item ID: Revision ID:	D350-591-			Accept	*N9000	<b>140</b>	100	)*	Setup Sta	1 /1	S1*
Start Date:	rt Date: 9/26/12 Start Qty: 10.00 uired Date: 10/19/12 Req'd Qty: 10.00 erence:		*10* *10*		Cust Item IE Customer:	<b>)</b> :				* ^N	S2*
Approvals:		lan:		Tooling: SPC (Y/N):	Dat	te:		]	Run Sta Sta	on	R1* R2*
Sequence ID/ Work Center II 190 *100* QC Quality Control	)	Operation Description QC10- Inspect visual per Memo	QSI004- ground welds	Set Up/ Run Hours 0.00 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 * <b>200*</b> QC Quality Control		QC5- Inspect part comple  Memo	eteness to step on W/O	0.00	)AS 16, 17/10/1(	-		410 RM			· ·
*210 * <b>210</b> HandFinish		Chemical Conversion Coa	at per QSI005 4.1	0.00			1	ŅΧ	6		My

Hand Finishing

											DQA:	Date	2:
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORM	MANCE / UPI	DATE			÷
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Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	•
Part I	- - No.					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube  Machining noforming  Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	T	Initial	Act	ion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ct	nief Eng	Descr	ription	Date	Verification	QC Inspector
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Other								1,					
Process								•					
Supplier													
Training			ļ										
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Landi	ng G	ear				General		_			_		_
		Bending				Bend		Grain			Ovalized	L	Pressure/Forced
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		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct _	Weld
		Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/l	Jnclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		
	ŀ	leat Trea	t			Countersink		Mislabe	led		Positioned \	Vrong _	_
	[ ]ı	nspection	n Strip in	Tube		Cut Too Short		Misread	l		Power Loss/	'Surge	Other
	F	Ripples in	Bend			Drill Holes		Offset			_	_	

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

Work Orde September-26-1				*907	770*						Page 5
Item ID: Revision ID: Item Name:	D350-591-3 Heli-Access-S	12 Step, Long RH		Accept	*N900	040	100	)* ፡	Setup Sta	I VI	S1* S2*
	9/26/12 10/19/12	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item 1 Customer:	ID:					OZ.
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:		i	Run Sta	" <b> \</b>	R1* R2*
Sequence ID/ Work Center II 220 **20* Powdercoat Powder Coating			17:00	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty  (1) X	Reject Qty	Reject Number	Insp. Stamp  M7  12/10
230 *230* HandFinish		Wing Walk as per dwg Q:	Si005 4.4 Batch <u>N/\ ( 7 7</u> )	539 0.00 0.00				10194	d	M	110

240

QC3- Inspect Part Finish

0.00

\*24**0**\*

Hand Finishing

Memo

0.00

Quality Control

10 fet & 10/0-16 000

											DQA:	Dat	te: _	<u> </u>
NCR:	Yes /	No				WORK ORDER NON-C	COI	NFOR	MANCE / UPDATE		·		_	•
											QA Closed:	Dat	te:	
Work Ord	or:					DISPOSITION			AGAINS	T DE	PARTMENT	PROCESS		•
Work Old	E1. —					Rework	<sup>ا</sup> [	j	Skid-tube Crosstub	_ [	1 .	Water Jet	$\neg$	Engineering
Part I	No.					Scrap	1 '	]	Machining Small Fa		Pro	d. Eng. Coor.	$\neg$	Quality
					<del></del>	Use-as-is	1		noforming Finishin		-1	e/Packaging		Other
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Root					Descri	ption of work order update	$\Box$	Initial	Action		Sign &			
Cause	] [	Date	Step	Qty	(	or Non-conformance	Cr	nief Eng	Description		Date	Verification	n	QC Inspector
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Equip/Tooling	Ш													
Operator														
Material														
Setup	Ш													
Other													1	
Process						•								
Supplier	Щ													
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							AUL	LT CATE	GORY					
Landi	ng Gea					General	_	J			Ovalized	I	П	Pressure/Forced
,	⊢	nding			a,,  -	Bend	$\vdash$	Grain		$\vdash$	4	**!		Temperature/Cure
	_		t Concer	itric to t	<sup>0/S</sup>	BOM/Route	$\vdash$	Hardwa		-	Over/Under		—	•
	Cra					Broken/Damaged	-	<b>-i</b> `	on Incomplete	$\vdash$	Part Incorred			Weld
	Crushed/Crimped.					Burrs	-	4	ions Incomplete/Unclear	-	Part Lost/Mi	22111g	لـــا	Wrong Stock Pulled
	Cuf					Countersink	-	Mainte		$\vdash$	Part Moved Positioned W	Irona		
L LL	I IHA	at Treat				IL OHDI PESIDK	1	TIVIISIADE	980	- 1	arosinonea v	ALOHE		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Work Orde September-26-1.				*907	770*						Page 6
tem ID: Revision ID:	D350-591-3	12		Accept	*N900	<u>040</u>	100	)* s	etup Sta	art *N	IS1*
tem Name:	Heli-Access-S	tep, Long RH							St	op *N	S2*
		Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item I Customer:	ID:					
Approvals:	Process Pla	n:	Date:	Tooling:	D:	ate:	-	R			R1*
	QC:		Date:	SPC (Y/N):	Da	ate:			Ste	<sup>op</sup> *N	R2*
Sequence ID/ Work Center II	D	Operation Description Pick Kit		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*250* Packaging Packaging		Memo		0.00				<u> </u>	<u> </u>		12/10/178
60	•	QC4- 100% Inspect kits for	or completeness	0.00 <b>QAS</b>	<b>.</b>						
* <b>260*</b> QC Quality Control		Memo		0.00	17/1472			PH			
70				0.00				<b>C</b> 4			
*270* Packaging		Packaging Memo		0.00		1	102)	X	<del></del>	12	1,0/23 ST
ackaging			ack for shipping as per PP					-			,

Packaging

NCR:	Yes	/ No				WORK ORDER NON-	-CO	NFORM	MANCE / UPD	DATE			•
											QA Closed:	Date:	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	•
Part N	- No					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	T				Descri	ption of work order update		Initial	Acti	on	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Cł	nief Eng	Descri	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved							EALU	LT CATE	<b>SOBA</b>	`			
Landii	ng Ge	ar				General						<del></del>	
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Wayes in Extrusion				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/U nance Ied	nclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

			*907	770*						Page	7
			Accept	*N900	<u>040</u>	100	)* ፡		ı		
9/26/12	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item l Customer:	ID:			_	~i	NSZ"	
Process Pla	an:	Date:	Tooling: SPC (Y/N):				. 1		• •	NR1* NR2*	
)	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	•		• ··
	D350-591-3 Heli-Access-9/26/12 10/19/12  Process Pla	Process Plan: QC: Operation Description QC21- Final Inspection -	D350-591-312   Heli-Access-Step, Long RH   9/26/12   Start Qty: 10.00   *1 \( \)*   *10/19/12   Req'd Qty: 10.00   *1 \( \)*   *1 \( \)*   Process Plan:	D350-591-312   Accept	10:33:50 AM	10:33:50 AM	10:33:50 AM	10:33:50 AM	D350-591-312	D350-591-312	D350-591-312

N (Mas 24)

											DQA:	Dat	e: _	<u> </u>
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORM	MANCE / UP	DATE				
											QA Closed:	Dat	e:	
Work Ord	or:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		•
Work Ord	C1.					Rework	7		Skid-tube	Crosstube	1	Water Jet	$\neg$	Engineering
Part !	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	$\dashv$	Quality
			,			Use-as-is	7		noforming	Finishing	4	re/Packaging		Other
NCR I	No.					Work Order Update			Large Fab	Composite	]	Supplier		
Root			<u> </u>		Descrit	tion of work order update	Т	Initial	Act	tion	Sign &		- T	
Cause		Date	Step	Qty	-	or Non-conformance	- 1	nief Eng		ription	Date	Verification	,	QC Inspector
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Landi	ng G	Gear				General		_			_	-		
	Ш	Bending				Bend	L	Grain			Ovalized	ļ	_	Pressure/Forced
	Ш	Centre No	ot Concer	ntric to C	)/S	BOM/Route	L	Hardwa	re		Over/Under	tolerance	·	Temperature/Cure
	Ш	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	—	Weld
	Ш	Crushed/	Crimped.			Burrs	L	Instruct	ions Incomplete/I	Unclear	Part Lost/M	issing	'	Wrong Stock Pulled
	Ш	Cuffs				Contamination		Mainte			Part Moved			
	Heat Treat					Countersink	_	Mislabe	led		Positioned V	· .		
		Inspection	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss/	Surge		Other
		Ripples in	Bend			Drill Holes	1	Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio September-26-12 10:33:47 AM

Work Order ID:

90770

Parent Item:

D350-591-312

Parent Item Name:

Heli-Access-Step, Long RH

**Start Date: 9/26/12** 

Required Date: 10/19/12

**Start Qty: 10.00** 

Required Qty: 10.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3572-1

JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164

DD verified by:eC

IPP Rev:D fixe route seq in bom DD

	10.04.28 verified b	oy:EC					-						
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1		Manufactured	No			110	Each	35.0000	1	10	1		
Step									-		-te-	12.	10.02
				<b>Location</b>		Loc Oty	Le	oc Code					
				WA <b>39</b> 0	3709 -	<b>-&gt;</b> 35			(/	<u>0)</u>			
				8968	33	10							
				8968		10							
D20/E 4				8968	35	5						V	
D3067-1		Manufactured	No			110	Each	56.0000	1	10	$\mathcal{M}$	12.10	2.10
End Plate									c	×	. <u> </u>	/ <i>&amp;</i> ·/C	)_/
				Location		Loc Oty	<u>L</u> e	oc Code		_			
					DIFF_	52				\displaystart \tag{\infty}			
				7860		4							
				8385		1							
				8692 8783		45 2							
				WA016	12	4							
				WAU16 6758	2	2							
				6821		1							
				7960		1							
D3219-1		Manufactured	No			110	Each	170.0000	2	20			
Plate		Transacture Cu									17.	12 . 10	.10
				Location		Loc Oty	<u>Lo</u>	oc Code					
				WA		152							
				8385	2	92							
				8888	8	60				20			
				WA016		18							
				7341		12							
				7767	4	6			-				

											DQA:	Dat	:e: _	•
NCR:	Yes	/ No				WORK ORDER NON-	-co	NFORM	MANCE / UPE	DATE				4.
						· · · · · · · · · · · · · · · · · · ·		<del>,</del>			QA Closed:	Dat	:e:	
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		•
Part   NCR	No.					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update	<u> </u>	Initial	Acti	on	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Cł	nief Eng	Descri	iption	Date	Verification	۱ ۱	QC Inspector
Doc/Data														
  Equip/Tooling												:	İ	
Operator							1							
Material			1											
Setup														
Other			]											
Process														
Supplier	П						-							
Training	П													
Unapproved														
							FAU	LT CATE	GORY					
Landi	ng G	iear				General		_			_			
		Bending				Bend		Grain			Ovalized			Pressure/Forced
		Centre N	ot Concer	ntric to O	/s	BOM/Route		Hardwa	re		Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct		Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/U	Inclear	Part Lost/M	issing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Moved			
		Heat Trea	at			Countersink		Mislabe	eled		Positioned \	Vrong		
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss,	′Surge [		Other
	П	Ripples in	Bend			Drill Holes		Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio September-26-12 10:33:48 AM

Work Order ID:	90770									
Parent Item:	D350-591-312						Star	t Date: 9/26/12		Required Date: 10/19/12
Parent Item Name:	Heli-Access-Step, Long RH						Sta	rt Qty: 10.00		Required Qty: 10.00
D3066-1 Spacer	Manufacture	d No			180	Each	75.0000	2	20	B90346 (20)
			Location	<u>n</u>	Loc (	<u>ty</u>	Loc Code			Le 12.10.13
			WA			75				
				85449		15				
				89399		60				
MS20600-AD4W4	Purchased	No			180	Each	2,746.0000	16	160	Ac 12.10.13
Rivets										The 12.10.15
			<u>Location</u>	<u>1</u>	Loc (	ty	Loc Code			
			321			18				
				121652		18		-		
			ST311		1	000				
				123021	1	000				
			ST321		1	728				
				121011		9				
				121340		39		-6	<u> </u>	
				121444		680		(160	ပည) ၂	_
D3065-041	Manufacture	d <sup>No</sup>			180	Each	11.0000	1	10	B00022 (18)
Step Leg Assembly Hi										B88822 (10)
			Location	<u>)</u>	Loc C	<u>ty</u>	Loc Code			An 12.10.13
			ST			-20				- 60
				85083		10				
			WA			1				
				66149		0				
				79336		1				
			WA013			30				
										•

NCR:	Yes /	No				WORK ORDER NON-O	100	NFORI	MANCE / UP[	DATE			*
									•		QA Closed:	Date	:
Work Ord	or:				-	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	•
Work Ord	···					Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part I	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is	1		noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR I	No				·	Work Order Update	]		Large Fab	Composite		Supplier	
Root	T				Descri	ption of work order update		nitial	Act	ion	Sign &		
Cause	Da	ite S	Step	Qty	C	or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material											:		
Setup													
Other													
Process	$\square$												
Supplier	H												
Training	$\vdash$								ļ				
Unapproved					`		<u> </u>	T CATE	CORY		<u> </u>		
	6				• • • • • • • • • • • • • • •	General F	AUL	T CATE	GUKY				
Landi	ng Gear Bend	lima.				Bend		Grain		<u></u>	Ovalized		Pressure/Forced
		-	oncon	tric to C	\s\-	BOM/Route	$\vdash$	Hardwa	uro	<del> </del>	Over/Under	tolerance	Temperature/Cure
	Crac		Joncen	itric to C	″³	Broken/Damaged	$\vdash$	ł	ion Incomplete	-	Part Incorred	<del></del>	Weld
	<del></del>	N3 hed/Crir	mned		-	Burrs		1	ions Incomplete/U	Inclear	Part Lost/Mi	<u> </u>	Wrong Stock Pulled
	Cuffs	-	inped.		-	Contamination		Mainte	•	- Incical	Part Moved		
	$oldsymbol{\vdash}$	Treat				Countersink	$\vdash$	Mislabe		-	Positioned V	Vrong	
	┝──┤	ection St	trip in	Tube		Cut Too Short	H	Misread		<del></del>	Power Loss/	_	Other
	<b>⊢</b>	es in Be	· · ·			Drill Holes	H	Offset		<b>L</b>	J	·	
				xtrusion		Drawing		ł	Calibration				
		ing Sequ			<del></del>	Finish		Out of S	Sequence				

Outside Dimensions

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

September-26-12 10:33:48 AM

Work Order ID: Parent Item: D3067-1 End Plate

90770

D350-591-312

Parent Item Name:

Heli-Access-Step, Long RH

Manufactured

Purchased

Manufactured

No

No

No

Location

89106

83858

ST470

ST481

**Start Date: 9/26/12** 

Required Date: 10/19/12

**Start Qty: 10.00** 

Required Qty: 10.00

Location	Loc Oty	Loc Code	•	, ,
WA B90 <b>17</b> 7	52		<u></u>	
78608	4			
83855	1			
86923	45			
87832	2			
WA016	4			
67582	2		<del></del>	
68214	1			
79607	1			•
	250	Each 94.0000	220 / 0	(C)

56.0000

		<u>Locatio</u>	<u>n</u>		Loc Qty		Loc Code
		FG			10		
			122800		10		
		ST353			84		
			122800		84		
Manufactured	No			2	50	Each	56.0000

Location	Ī	Loc Qty		Loc Code
ST471		50		
	88262	50		
ST481		6		,
	83853	6		
		250	Each	63.0000

Loc Qty

40

40

23

23

180

Each

	•	
63.0000		
Loc Code		

NCR:	Yes / No				WORK ORDER NON-C		NFOR	MANCE / UPI	DATE			•
							,			QA Closed:	Date:	
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	•
Part N					Rework Scrap		1	Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
rarer	···,				Use-as-is	1 1		noforming	Finishing		re/Packaging	Other
NCR N	No	<u> </u>		-	Work Order Update			Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	i	nitial	Act	ion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material			ł									
Setup												į
Other	_											
Process	_											
Supplier	_											
Training	_											
Unapproved	<u> </u>	<u> </u>	L	<u> </u>	E.	<u> </u>	T CATE	GORY		<u></u>		L
Landir	ng Gear				General	<u> </u>	.i CAIL	JONT				
[	Bending				Bend		Grain			Ovalized		Pressure/Forced
1	Centre No	ot Concer	ntric to	o/s	BOM/Route	-	Hardwa	re		Over/Under	tolerance	Temperature/Cure
Ì	Cracks			·	Broken/Damaged		1	ion Incomplete	<u></u>	Part Incorre	<del></del>	Weld
	Crushed/	Crimped.			Burrs		1	ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
Ī	Cuffs	·			Contamination		Mainte	nance		Part Moved		•
ľ	Heat Trea	ıt			Countersink		Mislabe	eled		Positioned V	Vrong -	_
Ī	Inspection	n Strip in	Tube		Cut Too Short		Misread	d		Power Loss/	Surge	Other
	Ripples in	Bend			Drill Holes		Offset		<del></del>			
[	Torque W	aves in E	xtrusio	n [	Drawing		Out of 0	Calibration				
[	Turning S	equence			Finish		Out of S	Sequence				

Outside Dimensions

Date: \_\_\_

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-26-12	10:33:49 AM									1 age 4
Work Order ID: Parent Item: Parent Item, Name:	90770 D350-591-312 Heli-Access-Step, L	ong RH						rt Date: 9/26/12 rt Qty: 10.00	Required Date: 10/ Required Qty: 10.	
AN960JD416 Washer	NAS1149D0463J	Purchased	No		250	Each	29.0000	160	18	<b>S</b>
Ab				Location ST351 116289	<b>Loc Oty</b> 29 8		Loc Code			<b>(</b>
AN960JD516 Washer	NAS1149D0563J	Purchased	No	119097	21 250	Each	2.0000	121255	JB	<b>\$</b> Z
110y				<u>Location</u> ST338 1069059	Loc Oty 2 2		Loc Code		V	·
Bolt		Purchased	No		250	Each	176.0000	20	~ JB	
				ST338 123021 ST340 122141 ST358 122808	50 50 26 26 100		Loc Code	122808		
Bushing		Manufactured	No	Location ST013	250 <u>Loc Oty</u> 99	Each	99.0000 Loc Code	20	-9010y/	110/17
				76130 84646 85446 86844	2 3 10 84			47-86844	- 7410Y /	E FO

NCR:	Yes	/ No				<b>WORK ORDER NON-</b>	CO	NFORM	MANCE / UP	DATE			•
	•	r									QA Closed:	Date	
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I NCR I						Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	-4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Cł	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved								T.CATE	CODY				
l andi						<del></del>	AUI	LT CATE	JURY				
Landi		Bending Centre No Cracks Crushed/G Cuffs Heat Trea Inspection Ripples in	Crimped. t n Strip in Bend	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	ion Incomplete cions Incomplete/ enance eled d	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Torque W	aves in E	xtrusion	n I	Drawing	1	[Out of (	Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date: \_\_\_\_\_

Turning Sequence

Wave/Twist in Tube

Finish

September-26-12 10:33:49 AM

Work Order ID:	90770						<u></u>					
Parent Item:	D350-591-312							Start 1	Date: 9/26/12		Required Date:	10/19/12
Parent Item Name:	Heli-Access-Step, I	Long RH						Start	<b>Qty:</b> 10.00		Required Qty:	10.00
D2230-35 Lug		Manufactured	No			250	Each	315.0000		40	JB	W.
rd				Locatio	<u>n</u> .	Loc Qty		Loc Code			V	
				FG		4						
					89045	4			<del> </del>			
				ST469		311						
					88185	48						
					89045	63						
					89782	200			897	182		
D2856-400	_	Manufactured	No			250	f	322.3994	1.2	12	- ,	$\Theta$
Abrasion Strip	<b>(</b> )										JB	
200				Locatio	<u>n</u>	Loc Qty		Loc Code				
- TON THE W	epal) =12/10/22			ST403		218.198						
0	- 7/10/22				81875	6.398						
	2/1				89352	211.8						
				ST409		104.2014						
					63735	0.6696						
					68076	0.3149						
					71164	8.46				<del></del> -		
					86905	94.7569			769	05		
MS21042133 Nut		Purchased	No			250	Each	2,157.0000	123	265	- 23B	12/19
				Locatio	<u>n</u>	Loc Oty		Loc Code		,	V	, ,
,				316		719						र्या
					122452	719					•	عت
				ST300		372			·		_	
					117885	32					-	
					119017	202						
					119075	138						
				ST317		1066						
					122141	1066						

											DQA:	Date	e:
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPI	DATE	QA Closed:	Date	e:
M. J. O. J						DISPOSITION AGAINST				AGAINST DI			•
Work Ord	er: .					D	1	1	الماريم لدنيا	Cun not what	7	Water Jet	Engineering
Part No.						▮		Small Fab Finishing		d. Eng. Coor. re/Packaging	Quality Other		
NCR No.					Work Order Update	]		Large Fab	Composite		Supplier		
Root					Descri	ption of work order update		Initial	Act	ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	Ш												
Operator	Ш												
Material													
Setup	Ш												
Other													
Process	Ш											1	
Supplier													
Training			· ·										
Unapproved							<u> </u>						
						F.	AUL	T CATE	GORY				
Landi	ng G	iear				General		,		<b></b>	<del>-</del> 1	_	<del></del>
	Ш	Bending				Bend		Grain			Ovalized	<u> </u>	Pressure/Forced
Landing Gear  Bending  Centre Not Concentric to O/S		o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure			
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
			Burrs		Instruct	ions Incomplete/l	Jnclear	Part Lost/M	issing	Wrong Stock Pulled			
		Cuffs				Contamination		Mainte	nance		Part Moved		
		Heat Trea	t			Countersink		Mislabe	led		Positioned \	Wrong _	
		Inspection	Strip in	Tube		Cut Too Short		Misreac	I		Power Loss/	'Surge	Other
		Ripples in	Bend			Drill Holes		Offset		<del></del>			
		Torque W	aves in E	xtrusio	n [	Drawing		Out of Calibration					

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish Folio September-26-12 10:33:49 AM

Work Order ID:

90770

Parent Item:

D350-591-312

Parent Item Name:

Heli-Access-Step, Long RH

Purchased

Purchased

No

**Start Date:** 9/26/12

Required Date: 10/19/12

**Start Qty: 10.00** 

Required Qty: 10.00

No 250 1,576.0000 80 Each Loc Otv Location Loc Code

	Docatio	<u>ıt</u>	Luc Qty	2	Luc Coue	
	FG		20			
		122808	20			
	ST356		1363			
		122416	498			
		122808	365			
		122993	500			
	ST357		193			
		120187	19			
		120770	12			
		121652	161			
		122063	1			
)			250	Each	1,452.0000	•
						1

Location	Loc Oty	Loc Code	
300	356		
121652	356		121652
314	1000		
122452	1000		
ST300	96		
108827	4		
116105	1		
116548	43		<del></del>
119109	36		
2937	12		

NCR:	Yes	/ No				WORK ORDER NON-	COI	NFOR	MANCE / UPD	ATE			•
-											QA Closed:	Date	:
Work Ord	er:					DISPOSITION			<b></b>	AGAINST DE	PARTMENT,		·
Part No				Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite		Small Fab	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other				
Root		Data	Cton	Otra		ption of work order update	1	Initial	Actio		Sign &	Verification	QC Inspector
Cause	1	Date	Step	Qty		or Non-conformance	Cr	nief Eng	Descrip	otion	Date	verification	QC Inspector
Doc/Data Equip/Tooling Operator													
Material	├	ł											
Setup	$\vdash$												
Other	_												
Process			]										
Supplier	-		1										
Training													
Unapproved	Г								:				
						F	AUL	T CATE	GORY				
Landi	ng (	Gear				General		_			_		_
 	L	Bending				Bend		Grain		<u> </u>	Ovalized		Pressure/Forced
	L	Centre No	ot Concer	ntric to C	)/S	BOM/Route		Hardwa	re	<u> </u>	Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	:t	Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/Ur	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		
		Heat Trea	t			Countersink		Mislabe	led		Positioned V		7
		Inspection		Tube		Cut Too Short		Misreac	İ		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes	_	Offset					
		Torque W	aves in E	xtrusion		Drawing		Out of 0	Calibration				

Out of Sequence

Outside Dimensions

Date:

DQA:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-26-12 10:33:49 AM

Work Order ID:

90770

Parent Item:

D350-591-312

Parent Item Name:

Heli-Access-Step, Long RH

Purchased

250

Each

No

**Start Date: 9/26/12** 

Required Date: 10/19/12

**Start Qty: 10.00** 

Required Qty: 10.00

				····	
	<u>Location</u>	Loc Qty	Loc Code		
	314	2738			
	122452	2738		122452	
	ST300	27			
	119017	20			
	121444	7			
	ST314	3000			
	123021	3000		<u> </u>	
No	)	250	Each 0.0000	40	
				17324X	1 -) / / ()

5,765.0000

NAS1149D0363J

Purchased

September-26-12 10:33:49 AM

NCR:	Yes	/ No			WORK ORDER NON-	100	NFORI	MANCE / UPD	ATE	QA Closed:	Date	• :
Work Ord	er:				 DISPOSITION	7			AGAINST DE	· · · · · · · · · · · · · · · · · · ·	_	·
Part No					 Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite		Finishing	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other		
Root Cause		Date	Step	Qty	Legion of work order update or Non-conformance	1	Initial nief Eng	Actio Descri		Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
					 F	AUL	T CATE	GORY				
Landi		iear Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection Ripples in Torque W	Crimped. t n Strip in Bend	Tube	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	ion Incomplete ions Incomplete/Ui enance eled	nclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/S	ssing /rong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



	DESIG	P	DRAWN BY	DART AEROSPACE. LTD HAWKESBURY, ONTARIO, CANADA	•
ı	CHECI		APPROVED	DRAWING NO.	REV B
L		2	TA	D3272 SHEET	1 OF 3
١	DATE			TITLE	SCALE
1	07.0	05.18		STEP ASSEMBLY, HI LONG	NTS
	Α		04.03.01	NEW ISSUE	
	В		07.05.18	D3272-1 WAS D2622-120	

RELEASED 0706 04

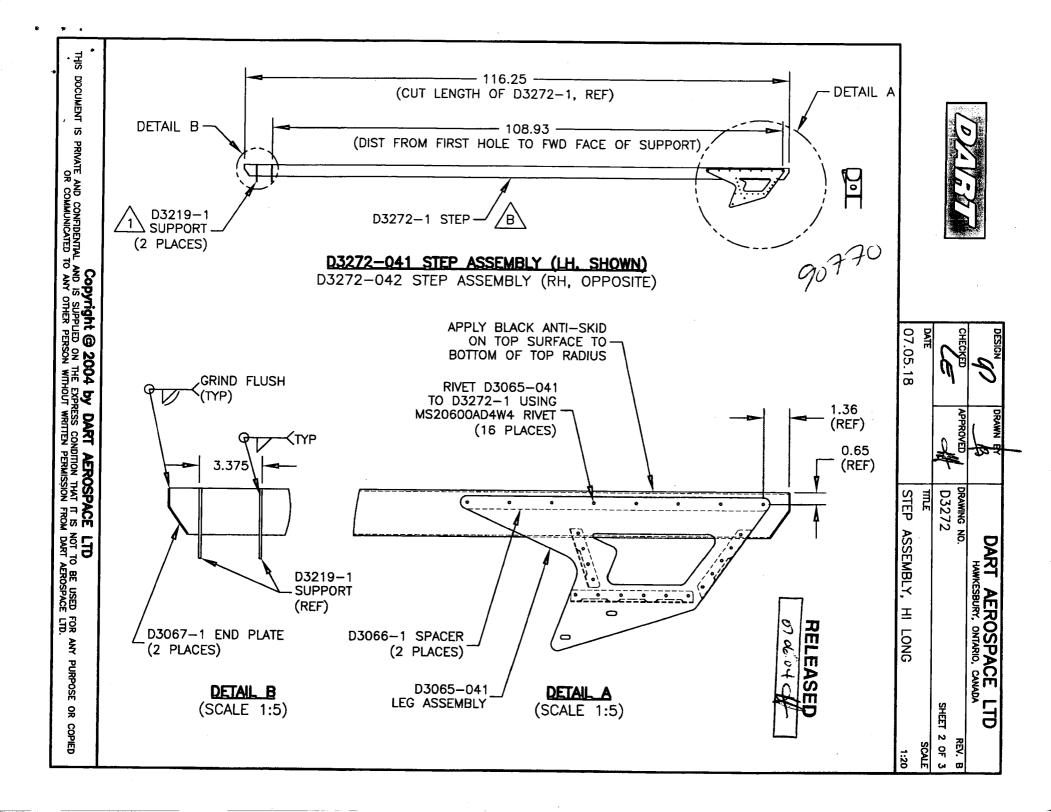
QTY -041	QTY -042	PART NUMBER	DESCRIPTION
Х		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	Х	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

## **GENERAL NOTES:**

- D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- WELD PER DART QSI 004
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SUBJECT TO AMENDMENT INCONTROLLED COPY WITHOUT NOTICE WORK ORDER ENGINEERING

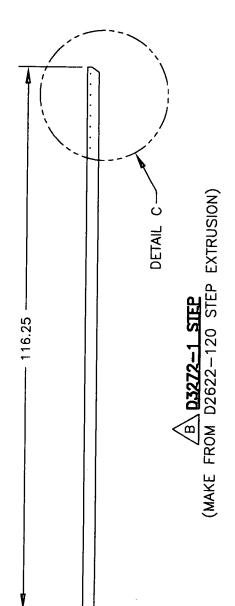
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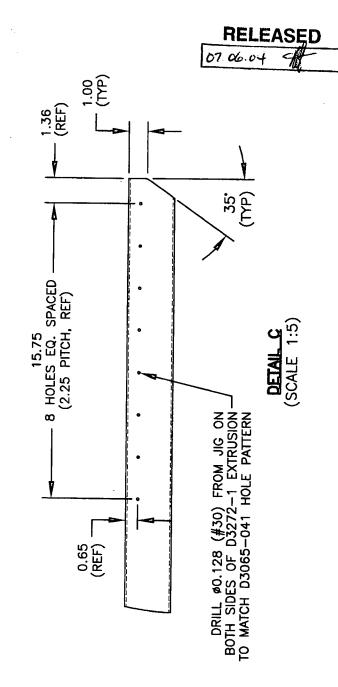






DESIGN	DRAWN BY	5.157.4.750.5	
P		DART AEROSPACE HAWKESBURY, ONTARIO, CAI	
CHECKED	APPROVED	DRAWING NO.	REV. B
CE		D3272	SHEET 3 OF 3
DATE		TITLE	SCALE
07.05.18		STEP ASSEMBLY, HI LONG	1:20





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## REFERENCE ONLY

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Oti. I	Oh	Oty I	Oty	Qty	Qty	Qty	Qfy	Part Number	Description
Qty -211	Qty -212	Qty -213	Qty -214	-215	-216	-311	-312	rait Number	Description
X X	-2.12	-210	-217	210		011	-	D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X	, ,						D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		Х						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
<b></b>			х					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				х				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
<b></b>					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						Х		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
t †							Х	D350-591-312	Heli-Access-Step™, Long Step - High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
T T						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			_D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	<b>L</b> 2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	/ 2	D2856-400-720	-ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							_D3080-1	CLAMP
						2 /	2	D3235-1	MOUNTING LUG
						1/	1	D3278-041	SUPPORT ASSEMBLY
							, _	ANGOSA	Phot T
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2		ļ	AN4-11A	BOLT
		4	4	4	4	8	/ 8	AN4-13A	BOLT
						2	2_2_	-AN5-36A	BOLT
4	4	4	4	4	4	4	74	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	12	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4 /	NUT
						2	72	MS21042L5	NUT
						1	1 1	*DSI 9410-011	STEP MODIFICATION KIT

<sup>\*</sup>DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.